

669-013

Dart Aerospace Ltd.

Date: Thursday, 20/11/2008 3:33:55 PM
 User: Julie Dawson

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : COBRA SKIDTUBE ASS'Y
Job Number : 43593A	
Estimate Number : 13181	
P.O. Number :	Part Number : D209669043
This Issue : 20/11/2008 S.O. No. :	Drawing Number : D2906 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : B
Previous Run : 43361A	Material :
Written By :	Due Date : 25/12/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 08.11.21</u>	
Comment : new est. 08.02.13 LL, verified by: DD	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D209-669 bluefile & type labels per PPP D205-669-041 chg 002

2.0

D25001190

Ext'n - I' Beam Tube 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2500-1-190

Skid Tube Extrusion

B40150 Pm 08-12-11

3.0

D29263

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

batch 94375060

Pm 08-12-12

4.0

SKIDTUBES 1

SKIDTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2906 if necessary Deburr ends

3-Acid etch and Alodine tube per QSI 005 4.1

B.E
Pm 08-12-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section-A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: COBRA SKIDTUBE ASS'Y

Job Number: 43593A

Part Number: D209669043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DD

8-12-12

6.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes using drill jig DT8149, DT8711-2 & DT8711-3 (Do not use cutting fluid)

2-Open holes to 0.500" as per Dwg D2906 without cutting fluid

3-Countersink holes as per Dwg D2906 without cutting fluid

4-Deburr and blow out all chips from inside of tube

5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty	Part Number	Description	Batch
A/R	Sikaflex-291	M109883	

Sikaflex expire date:

Start Time: 08:00 Date: 08-12-12

Fin Time: 9AM Date: 8-12-15

pick:

Qty	P/N	description	B/N
1	D2926-3	Web	B43756

7.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

1-Bend as per program COB41FWD & COBRAFT on CNC Bender and Folio FT

2-Cut tubes as per Dwg: D2906 & per template DT8185B & DT8185BC

DD 8-12-15

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends

2-Prepare tube for welding, remove alodine as required.

DD pm 08-12-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: COBRA SKIDTUBE ASS'Y

Job Number: 43593A

Part Number: D209669043

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/15 (X)

10.0

D2579

Crossbolt Spacer



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Pick:

Qty Part Number Description
19 D2579 Spacers

Batch

B41066

pm 08-12-15

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld crossbolt spacers D2579 as per Dwg. D2906 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R Aluminum Rod

M109560 BE 08-12-16

2-Grind welds as per Dwg D2906 Grind flush ridge made from bending

3-Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper not to hit web. Deburr

4-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2906, Deburr holes

5-Drill pilot holes for aft & fwd cap using DT8025 open holes to #6" Deburr

6-Drill pilot holes for Tow ring using DT8091-3 , open to .640" and Deburr

AWM
8-10-17

870

12.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D209-669-043 PAR #: 08-047 Fault Category: Prod / Skid tube NCR: Yes ☐ No ☒ DQA: AD Date: 28/12/22
 Resolution: SCAP Disposition: SCAP QA: N/C Closed: AD Date: 28/12/22

NCR: <u>43593A</u>		WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date		
08-12-18	12.0	<u>Originated at step 6.0</u> The holes from one side to the other are not aligned, and the saddles will not install properly (they are offset) R.C. AD4 locating jig was not square on the end of the tube.	<i>initial</i>	- Scrape & destroy the tube. - See PAR08-047 to have the act 515 DTG149 slotted to visually see if it is properly placed & bottomed out on the skid tube.	PM 08-12-19 DD 08-12-19 08-12-19	08/04/2 08/12/18	

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Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: COBRA SKIDTUBE ASS'Y

Job Number: 43593A

Part Number: D209669043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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14.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Pressure wash as per QSI 005

15.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
START TIME: _____
OVEN TEMPERATURE: _____
FINISH TIME: _____

16.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

17.0	D2855	Cap
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Cap
Batch: _____

18.0	AN35A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: _____

19.0	AN960JD10L	Washer
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer
Batch: _____

20.0	ALS71032130	Insert
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Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)
Insert
OR PER QSI 017
Batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

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Drawing Name: COBRA SKIDTUBE ASS'Y

Job Number: 43593A

Part Number: D209669043

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

21.0	AN3C4A	BOLT
------	--------	------



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)
BOLT
Batch: _____

22.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)
washer
Batch: _____

23.0	D25943	O-Ring, 205 Skidtube
------	--------	----------------------



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)
O-Ring
Batch: _____

24.0	D25941	Plug, 205 Skidtube
------	--------	--------------------



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)
Plug
Batch: _____

25.0	D35649	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
batch _____

26.0	D356411	Wearshoe
------	---------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
batch _____

27.0	D35645	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
batch _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: COBRA SKIDTUBE ASS'Y

Job Number: 43593A

Part Number: D209669043

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D35661

Gasket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
GASKET
batch _____

29.0

D35665

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
batch _____

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2906. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 _____

Sikaflex expire date: _____

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2906

3-Inspect for foreign object per QSI 024

4-Install D2855 Fwd & Aft Cap as per Dwg D2906 and seal Fwd & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 _____

Sikaflex expire date: _____

5-Wing Walk as per Dwg D2906 and QSI 005 4.4

Batch: _____

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D209-669-041

Location: _____

PPP Rev: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: COBRA SKIDTUBE ASS'Y

Job Number: 43593A

Part Number: D209669043

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-19

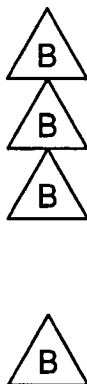
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



QTY -041	QTY -043	Part Number	Description
X		D2906-041	SKIDTUBE ASSEMBLY
	X	D2906-043	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
22	19	D2579	CROSS BOLT SPACER
12	14	D2594-1	PLUG
12	14	D2594-3	O-RING
2	2	D2855	AFT CAP
1		D2926-1	WEB
	1	D2926-3	WEB
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
1		D3564-15	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1		D3566-15	GASKET
50	44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
50	44	AN3C4A	BOLT
4	4	AN3-5A	BOLT
50	44	AN960C10L	WASHER
4	4	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
- 3) INSERT D2926-1/-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 9) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
- 10) ALL DIMENSIONS ARE IN INCHES.

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WITHOUT NOTICE
WORK ORDER
NO. 43593A

RELEASED

07.09.04

B	UPDATE DRAWING FORMAT; RE-ORGANIZE; ADD STAINLESS STEEL WEARPLATES AND GASKETS CHANGE WEARPLATE HARDWARE TO SS; PG 1: ADD NOTE 10; PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041; PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES;	CB	07.08.21
A	NEW ISSUE	CP	04.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN	97	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	21	D2906	SHEET 1 OF 3
APPROVED	10	TITLE	SCALE
DE APPR.	11	AH-1 (209) SKIDTUBE ASSEMBLY	NTS
DATE	07.08.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



RELEASED

07.09.04 #



**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:**

- 1. CHAMFER HOLE 0.050 X 45°**
- 2. INSERT D2579 SPACER (22 PLACES)**
- 3. WELD INTO PLACE AND GRIND FLUSH**

NLY:
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00 DEEP ENGINEERING
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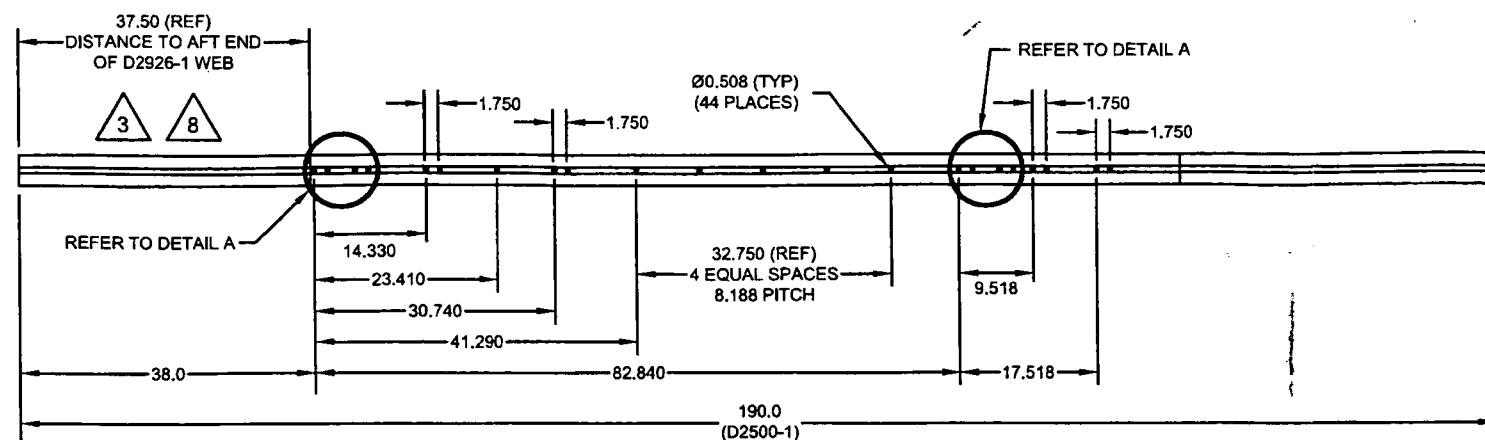
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

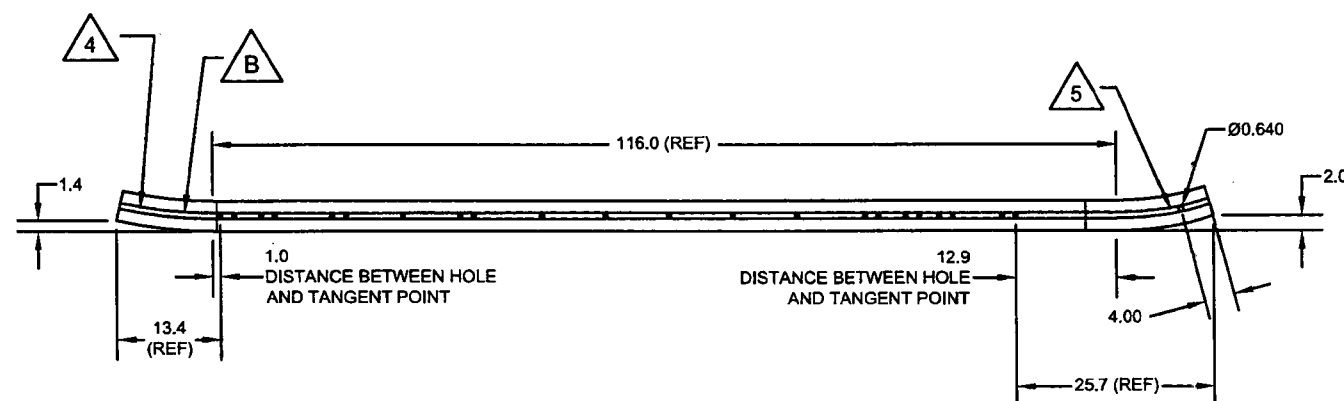
NO 43543H

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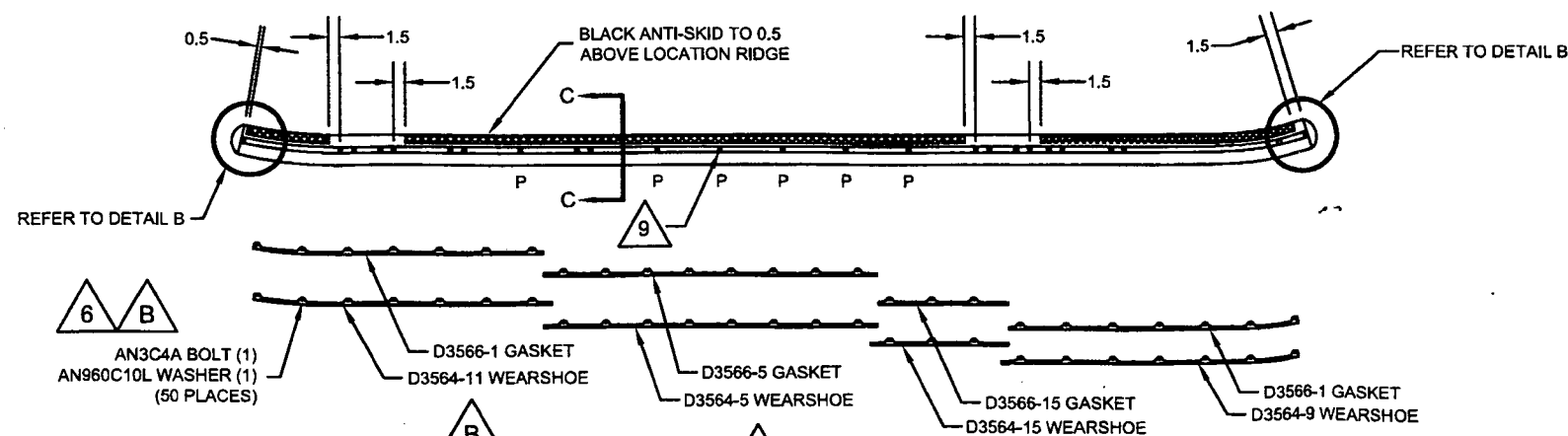
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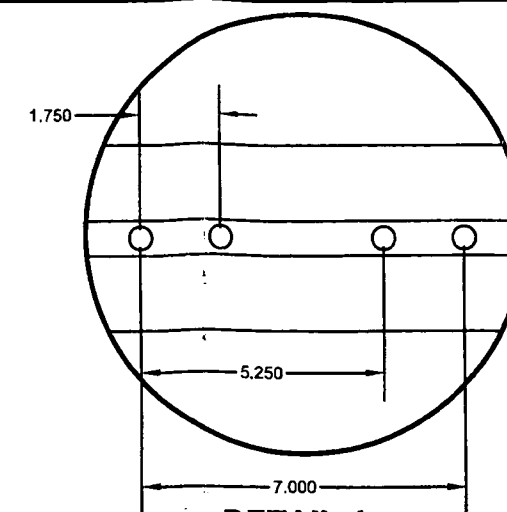
D2906-1 DRILLING DETAIL



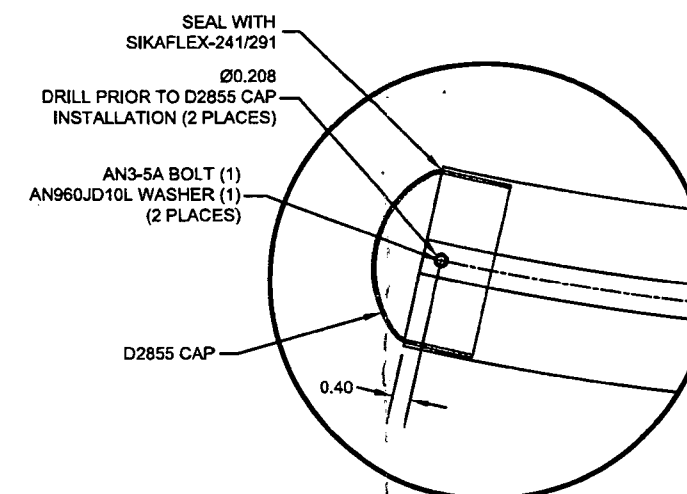
D2906-041 BENDING AND CUTTING DETAIL



D2906-041 ASSEMBLY DETAIL



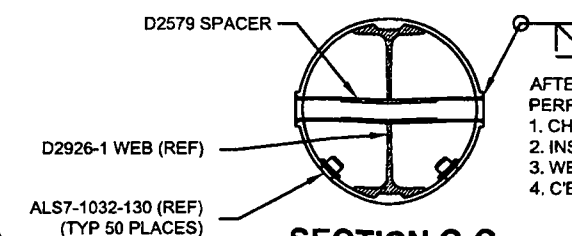
**DETAIL A
SCALE 1:4**



**DETAIL B
SCALE 1:4**

RELEASED

07.09.04



**SECTION C-C
SCALE 1:4**

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (22 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.000

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 135930

DESIGN	9P	DART AEROSPACE LTD	
DRAWN	C.B.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	21	D2906	SHEET 2 OF 3
APPROVED	21	TITLE	SCALE
DE APPR.	21	AH-1 (209) SKIDTUBE ASSEMBLY	1:24
DATE	07.08.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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